

Green

Dart Aerospace Ltd.

Date: Wednesday, 08/04/2009 11:15:07 AM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: LEVER ARM
<b>Job Number</b>	: 47094		
<b>Estimate Number</b>	: 12069		
<b>P.O. Number</b>	:	<b>Part Number</b>	: PB6743001261
<b>This Issue</b>	: 08/04/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: B6743001 PAGE39
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 44978	<b>Drawing Revision</b>	: B1
	<b>Type</b> : SMALL /MED FAB	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 15/04/2009
<b>Checked &amp; Approved By</b>	: <u>ME 09-04-08</u>	<b>Qty:</b>	10
<b>Comment</b>	: Est. A 05.06.07 New issue KJ/JLM Est Rev:B 08-06-23 now made on water jet DD verified by:EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0250X06000	6061-T6 Bar .250 x 6.00
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**Comment:** Qty.: 1.4574 f(s)/Unit Total: 14.5740 f(s)  
 6061-T6 Bar .25" x 6.0" 110913 189-4-13

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg B67-43001  
 Dwg Rev: B1  
 Prog Rev: B1

189-4-13

2-Deburr if necessary

189-4-13

M-L

04/04/15

(16)

(10x)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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189-4-13

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 09/04/15

(x10)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

BH 09-04-16

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 08/04/2009 11:15:07 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEVER ARM

Job Number: 47094

Part Number: PB6743001261

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



1118144



Comment: POWDER COATING

Powder Coat (Ref: 4.3.5 ) as per QSI 005 4.3

*Green Sandtex*

START TIME: 2:20pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 2:50am

*24 09-04-16*

*(10x)*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FL 09/04/16 (10)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST432

*SS 09/04/17 (x6)*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/04/22*

Job Completion



*MF 09-04-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



